

Work Order ID 83872

\*83872\*

Page 1

April-26-12 2:30:35 PM

Item ID: D3065-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Step Spacer

Stop \*NS2\*

Start Date: 26/04/2012 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 12/04/2012

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3065

Dwg Rev: B

Prog Rev: B

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

52

8

Jm/SA  
12-5-9

52

8

Jm/SA  
12-5-9

2024 040

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

*8.26.12*

*52*

130

Small Fab

0.00

\*130\*

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

*n 145*

140

NC BRAKE

0.00

\*140\*

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3065

*52*

*9/12/05/16*  
*SB 12/05/17*

# WORK ORDER CHANGES

PROCEDURE CHANGE

By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Start Date: 26/04/2012 Start Qty: 50.00 **\*50\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 50.00 **\*50\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		<i>S. Schultz</i>		<i>count</i> <i>ASZ</i>			
160 <b>*160*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				<i>52</i>		<i>W6125-17</i>	
170 <b>*170*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00				<i>Sax</i>		<i>12/05/08</i>	

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location: *GA*

0.00

\*180\*

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

*52x*

*12/05/12*

*12/05/12*

*MCS 12/05/12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-26-12 2:30:39 PM

Page 1

Work Order ID: 83872

**\*83872\***

Parent Item: D3065-1

**\*D3065-1\***

Parent Item Name: Step Spacer

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF  
IPP: D06.04.25Water jet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		100	sf	226.1912	0.1238	6.515789			

**\*M2024T3S 040\***

2024-T3 .040 sheet

**\*\***

Location

Loc Qty

Loc Code

MAT022

226.1911626

117684

21.318421

120196

42.41

120605

66.4627416

121197

96

121197  
6.5

Jm  
12-5-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	83872
<b>Description:</b> Step Spacer		<b>Part Number:</b>	D3065-1
<b>Inspection Dwg:</b> D3065	<b>Rev:</b> B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.251	✓		vern	HB-02
2.093	+/-0.010	2.094	✓		vern	HB-02
3.936	+/-0.010	3.937	✓		vern	HB-02
4.186	+/-0.010	4.188	✓		vern	HB-02
0.587	+/-0.010	0.591	✓		vern	HB-02
Ø0.128	+0.005/-0.001	0.128	✓		vern	HB-02
R0.125	+/-0.010	0.125	✓		RG	HB-02
3.465	+/-0.010	3.465	✓		vern	HB-02
Ø1.250	+0.012/-0.001	1.250	✓		vern	HB-02
0.368	+/-0.010	0.372	✓		vern	HB-02
0.871 (Pitch)	+/-0.005	0.873	✓		vern	HB-02
0.040	+/-0.010	0.039	✓		vern	HB-02

<b>Measured by:</b>	Jm/SA
<b>Date:</b>	12-8-9

<b>Audited by:</b>	S
<b>Date:</b>	12/05/09

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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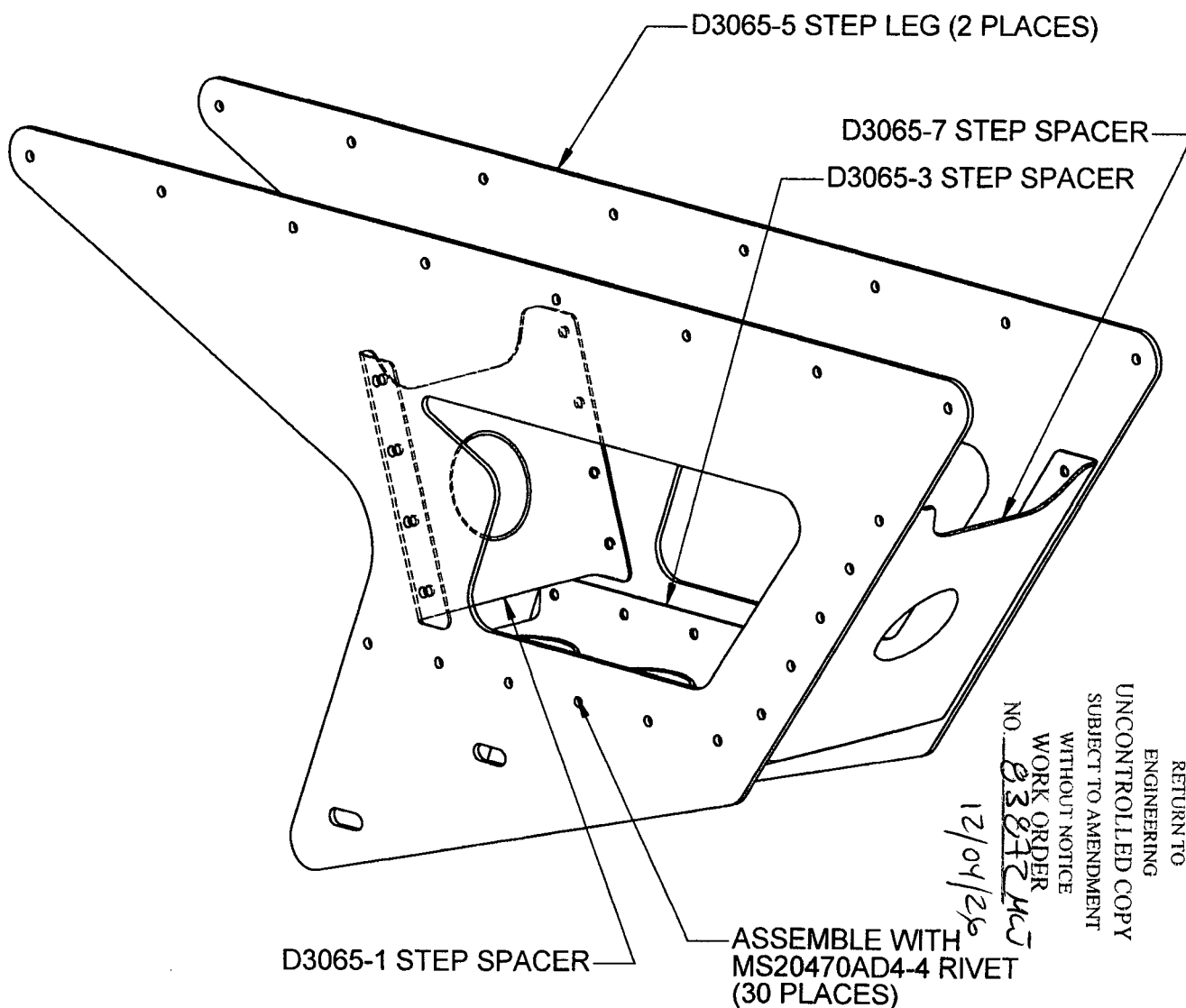
**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *8387240*  
12/04/20

## D3065-041 STEP LEG ASSEMBLY

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

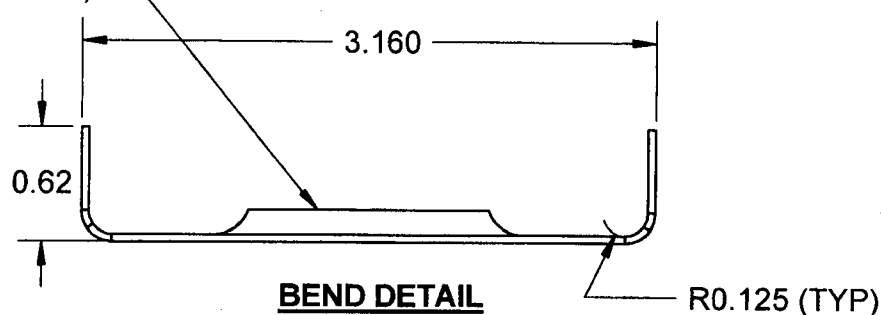
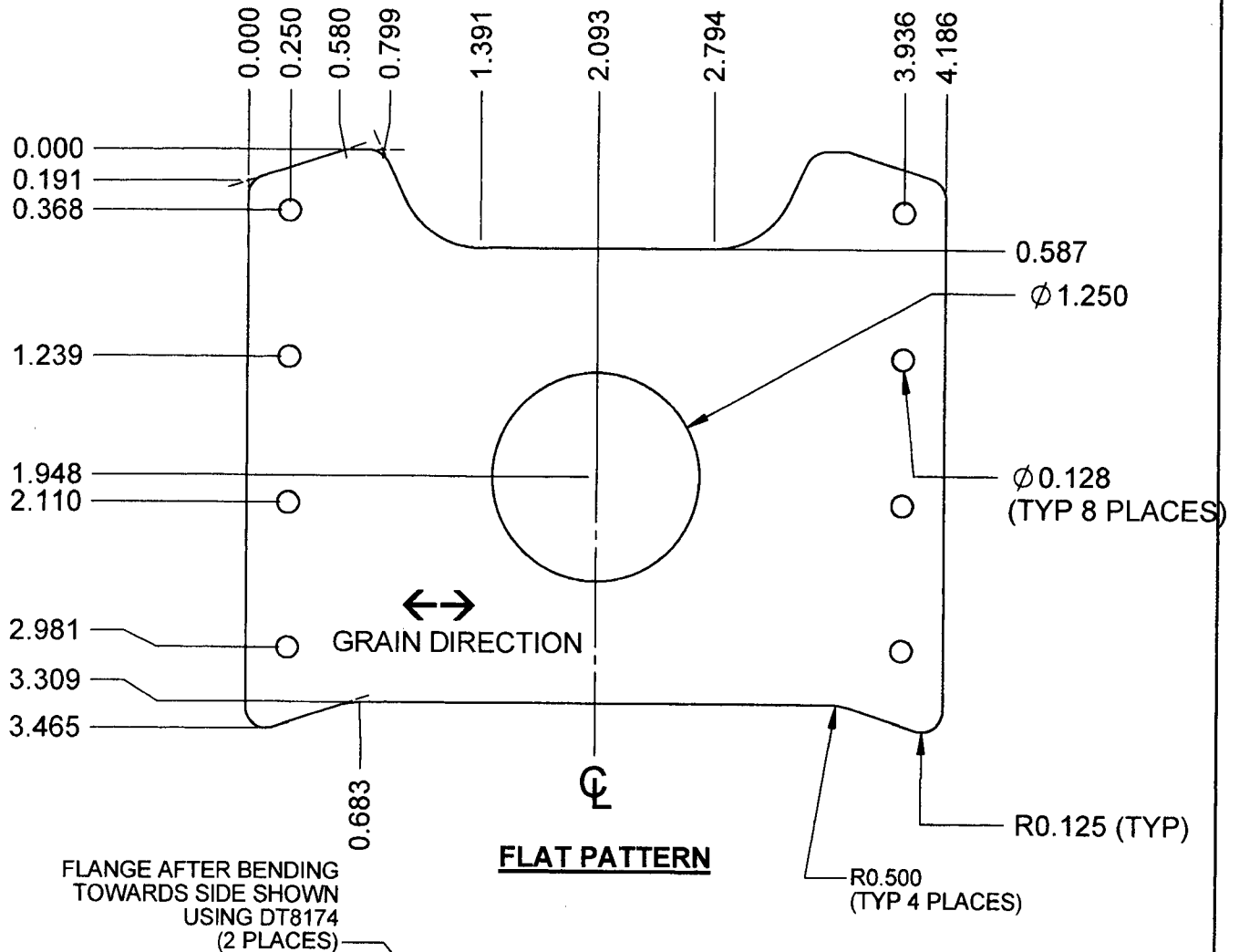
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**DART**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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*03072*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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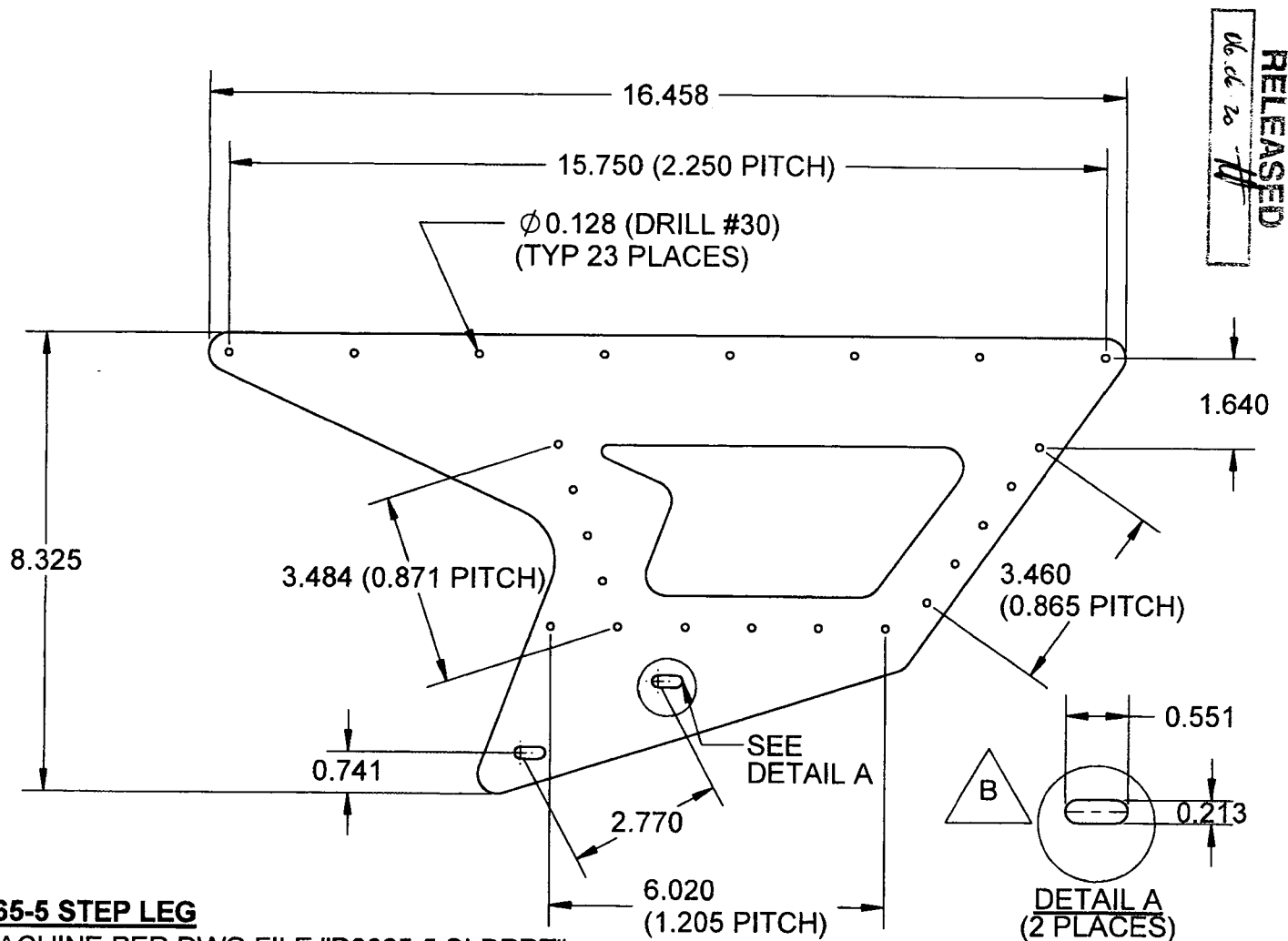
**NOTE:** Date & initial all entries



83872



DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	06.05.23	D3065	SHEET 4 OF 5
		TITLE	SCALE
		STEP LEG ASSEMBLY	1:3



### D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

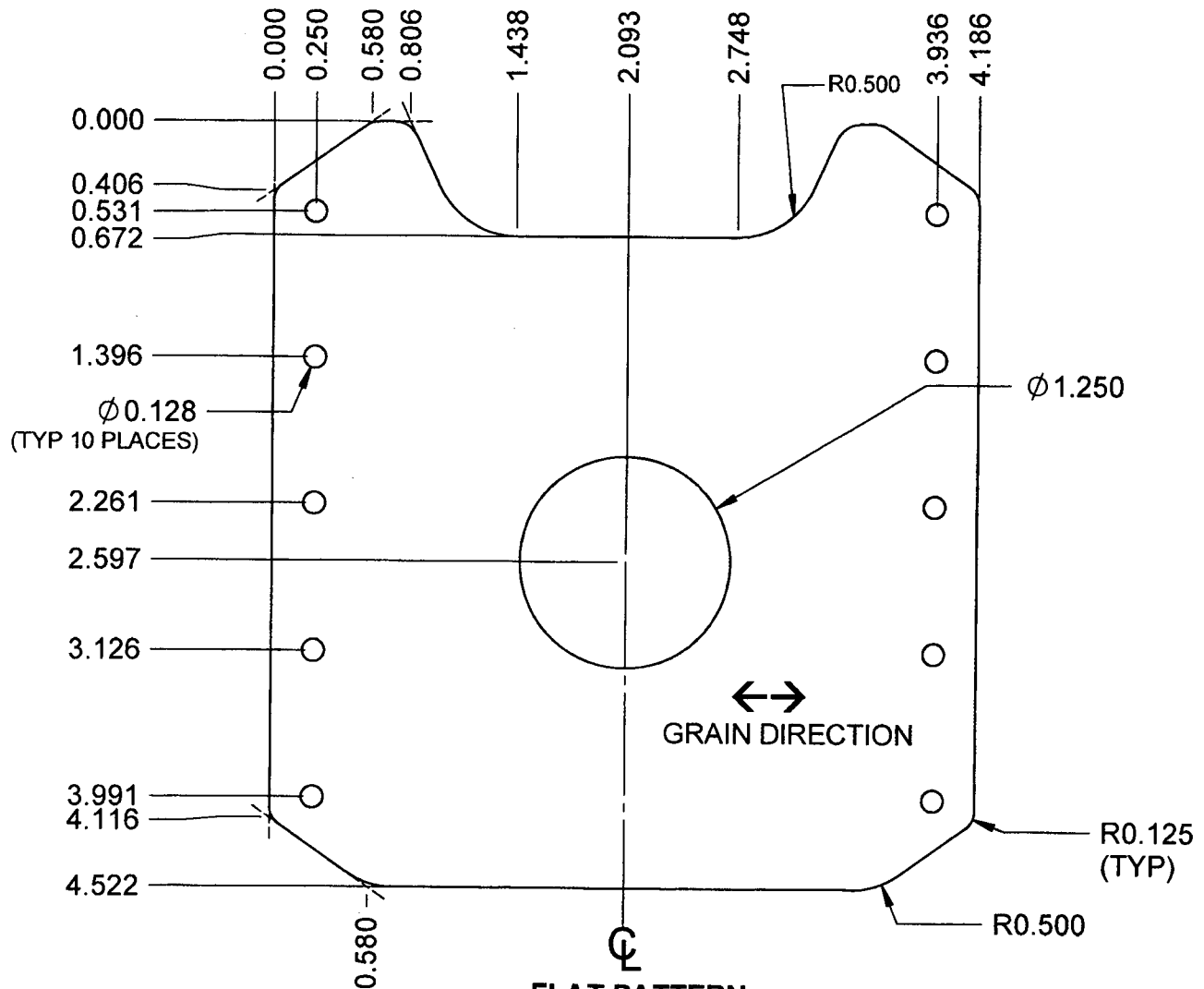
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**DART**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 5 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1

**FLAT PATTERN****RELEASED***06 06 20*

0.62

**BEND DETAIL**

R0.125 (TYP)

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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*03872*

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